



# Tinkering Paws

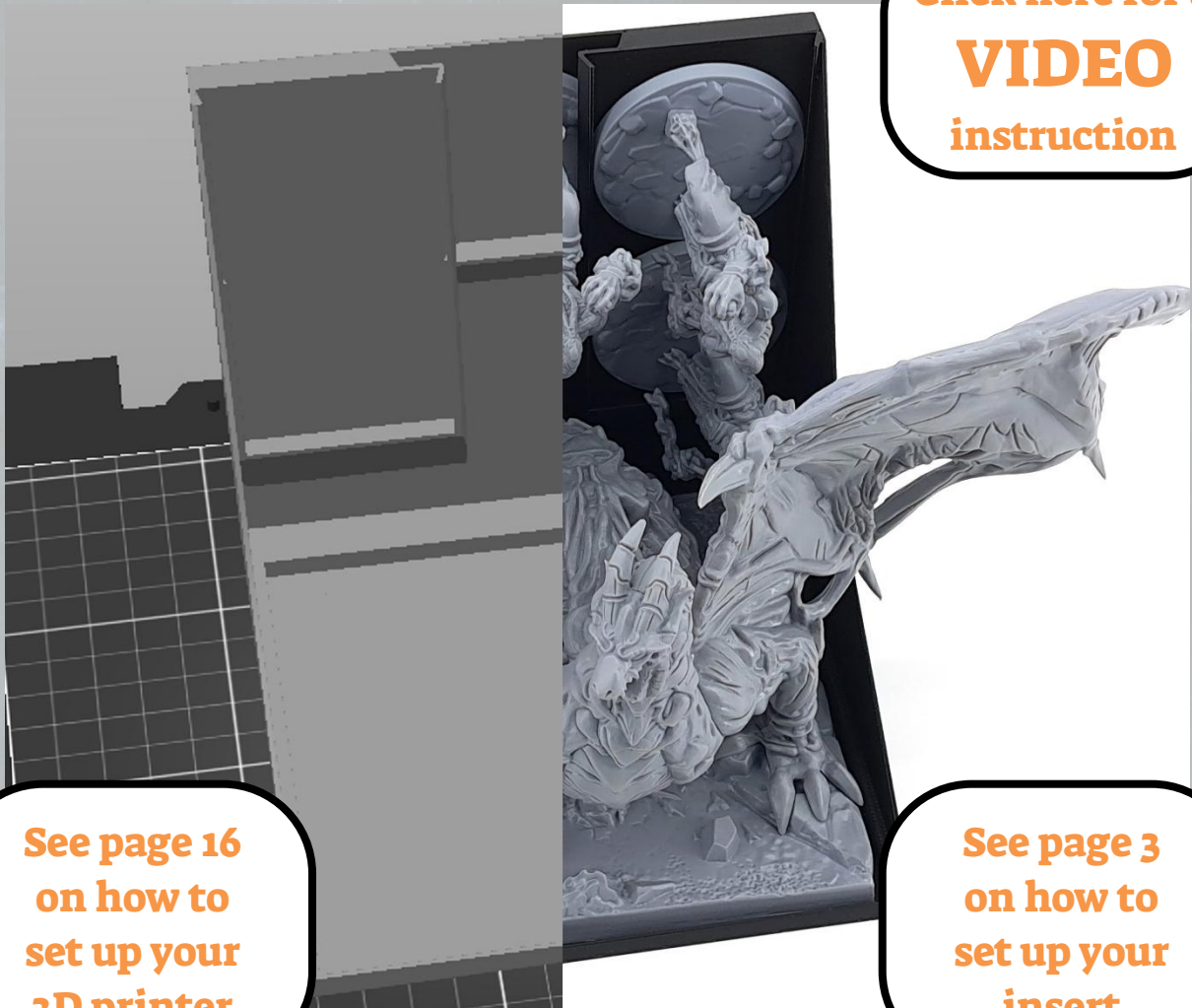
BOARD GAME INSERTS



## Twilight Imperium

4<sup>th</sup> Edition

- Premium Ship Boxes -



Click here for a **VIDEO** instruction

See page 16 on how to set up your 3D printer

See page 3 on how to set up your insert



## List of Contents

1. 8 Ship Boxes to store color-related components
2. 24 Faction Boxes to store faction-related components
3. 1 System Tiles Box
4. 2 Stackable Token Boxes
5. 3 Card Boxes
6. 1 Strategy Card & Dice Box

If you purchased this product after March 2025, all boxes are marked with a code (M1, M2, etc.) on their bottom.



### Ship Boxes #S1a & #S1b

These boxes store everything that is color-related:

- Plastic Units
- Color-specific Promissory Note Cards
- Color-specific Technology Cards
- Color-specific Unit Upgrade Technology Cards

See the next page for additional information.



### Ship Boxes #S1a & #S1b

1. Fighters
2. Dreadnoughts
3. Infantry
4. Space Docks
5. Carriers
6. Destroyers
7. Cruisers
8. Mech Units
9. PDS
10. Cards
11. War Suns & Flagship



The Box with Fighters is stored on top of the PDS & Mech Units compartments. (See image on the right). If you need any help with this step (or any other) contact us at [info@tinkeringpaws.de](mailto:info@tinkeringpaws.de)



## Faction Boxes #F1

These boxes store everything that is faction -related:

- Command Tokens
- Control Tokens
- Home Planet Cards
- Leader Cards
- Faction-specific Technology Cards
- Faction-specific Promissory Note Card
- Faction-specific Tokens (Creuss, Naalu, Nekro, UI)

If you have bought the Upgrade Pack, you might still have Faction Boxes with names instead of symbols. Some of those get replaced in the Upgrade Pack to allow more space for the cards.

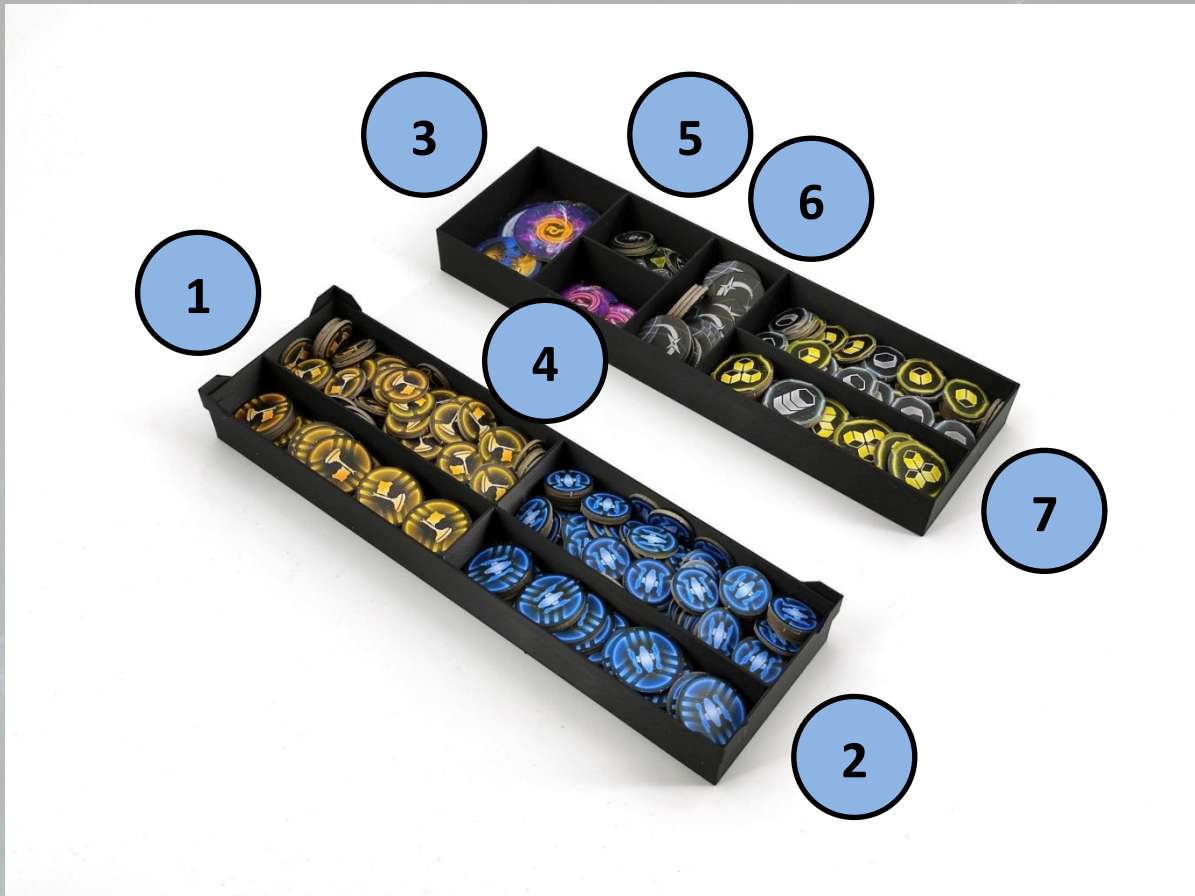


### System Tiles Box #ST1

This box stores the different system tiles.

Home System Tiles will fit in the tallest compartment, while Anomaly Tiles will fit in one of the other compartments. Split normal System Tiles and Hyperlane Tiles between the two remaining compartments. Malice and Creuss are placed in top of the other System Tiles. Make sure they are placed like in the picture below.





### Token Boxes #T1 & #T2

1. Infantry Tokens (Two compartments)
2. Fighter Tokens (Two compartments)
3. Miscellaneous Tokens (Destroyed Planet, Mirage, Ion Storm, Custodian, Speaker)
4. Gamma Wormhole Tokens
5. Attachment Tokens
6. Frontier Tokens
7. Trade Goods Tokens (Two compartments)

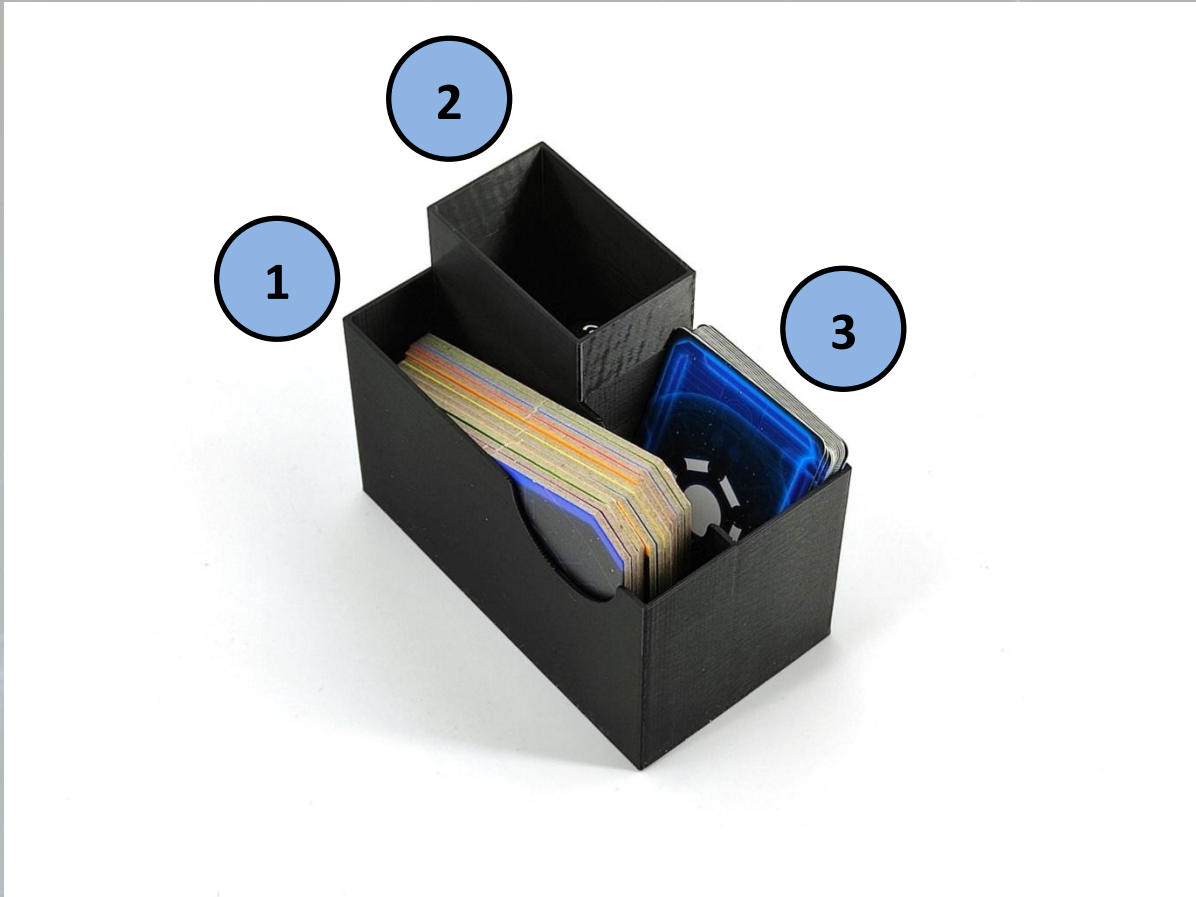




### **Card Boxes #C1, #C2 & #C3**

Depending on if you own only the Base Game or also the Prophecy of Kings expansion and if you use Card Sleeves, you will need one, two or all three Card Boxes.

The boxes come with dividers for every kind of card, and they are showing the same symbols as shown on the cards.



### Strategy Card & Dice Box #D1

1. Strategy Cards
2. Dice
3. Cards that get removed when using the Prophecy of Kings expansion



### Component Storage #1

Place four Ship Boxes like shown in the picture. Make sure they are orientated correctly.



## Component Storage #2

Place the remaining four Ship Boxes on top.



### Component Storage #3

Place the Faction Boxes and the Strategy Card & Dice Box in the remaining gap.



#### Component Storage #4

Place everything that is kept in plastic bags (Faction Sheets, Leader Sheets, Command Sheets) on the left, and all instructions and booklets on the right.



### Component Storage #5

Place the Card Boxes on the right and the Token and System Tiles Boxes on the left side.

# How to print your digital STL-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: **CS1\_x4.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

Print “S1a\_x8”, “S1a\_Lid\_x8” & “S1b\_x8” for the **Premium Ship Boxes** or “S2\_x8” and “S2\_Lid\_x8” for the **Standard Ship Boxes**.

## 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 STL-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 two options:

- Separate lid and icon for each faction
- One file with all lids and one file with all icon

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

For questions or feedback visit [www.TinkeringPaws.de](http://www.TinkeringPaws.de)

Or write an email to [info@tinkeringpaws.de](mailto:info@tinkeringpaws.de)