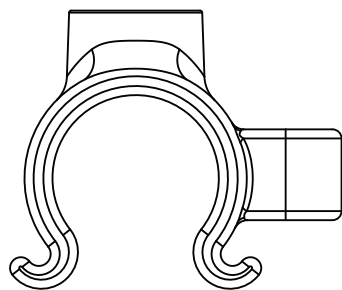
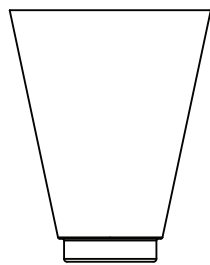


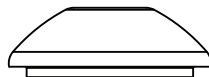
1



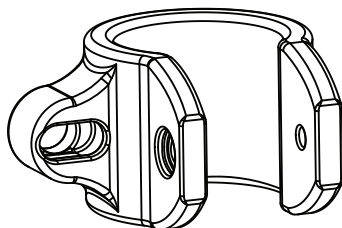
2



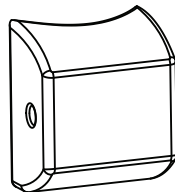
3



4

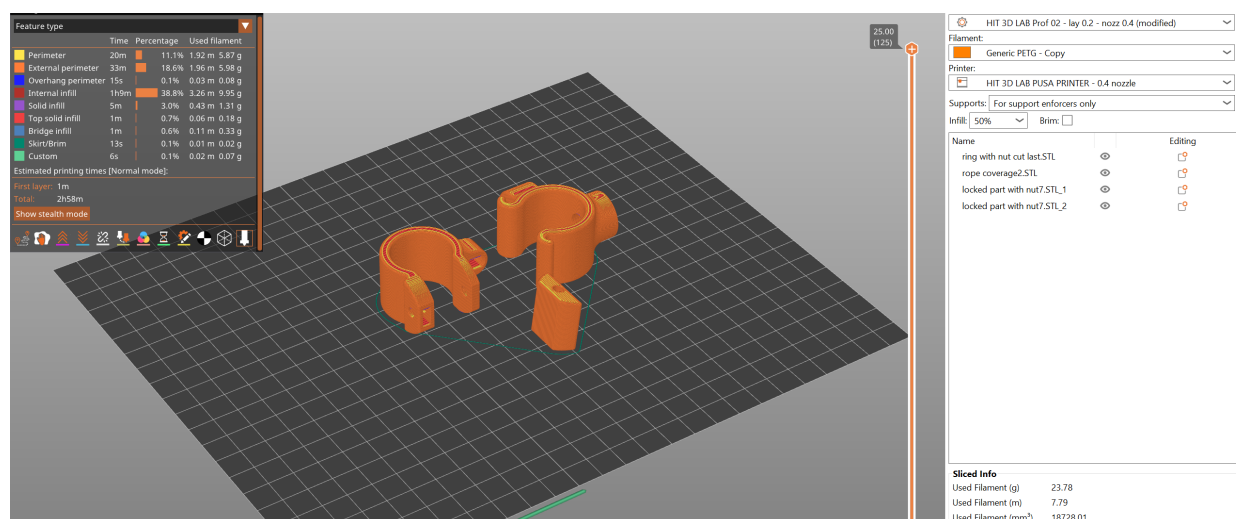


5



Download these files from the STL provided here.

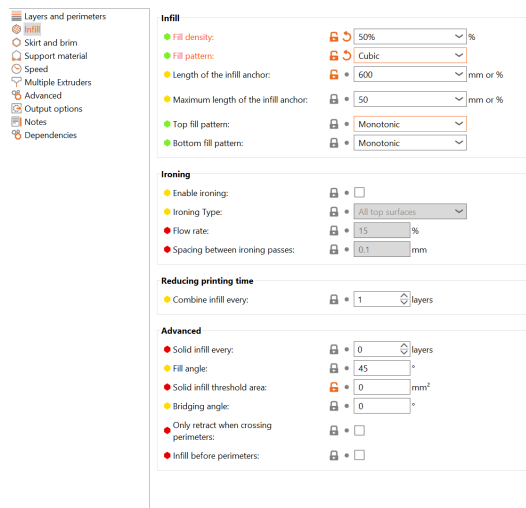
Print them using the said materials by a 3D printer according to the specifications listed below



Infill

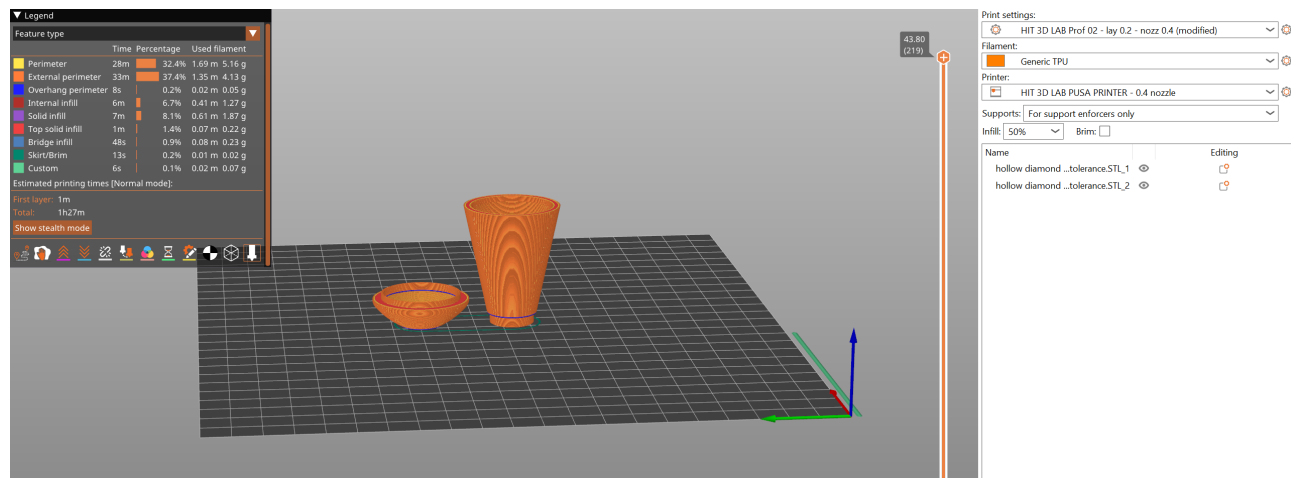
- **Fill density:** 🔒 ↺ %
- **Fill pattern:** 🔒 ↺
- **Length of the infill anchor:** 🔒 • mm or %
- **Maximum length of the infill anchor:** 🔒 • mm or %
- **Top fill pattern:** 🔒 •
- **Bottom fill pattern:** 🔒 •

3D print the parts collapsible ring, permanent ring main, and permanent ring lock using PETG filament and the following settings.

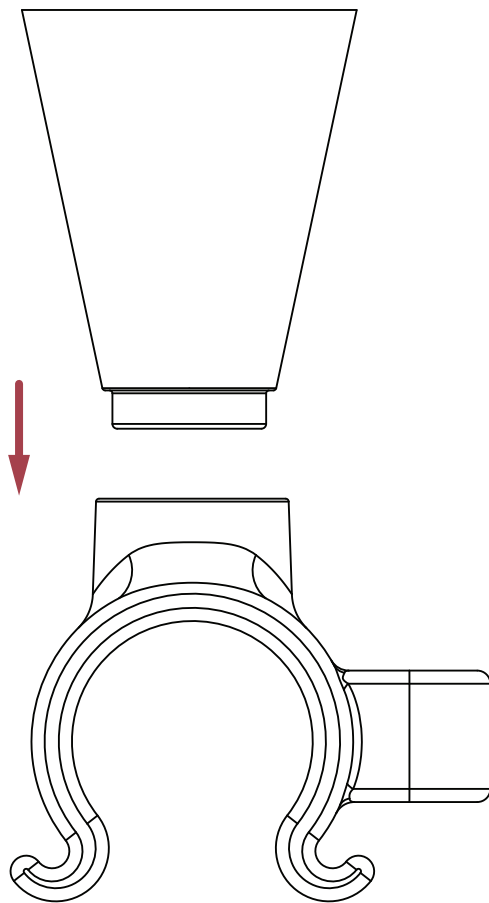


Speed for print moves

- Perimeters: 60 mm/s
- Small perimeters: 30 mm/s or %
- External perimeters: 30 mm/s or %
- Infill: 50 mm/s
- Solid infill: 50 mm/s or %
- Top solid infill: 45 mm/s or %
- Support material: 70 mm/s
- Support material interface: 100 mm/s or %
- Bridges: 40 mm/s
- Gap fill: 40 mm/s
- Ironing: 15 mm/s

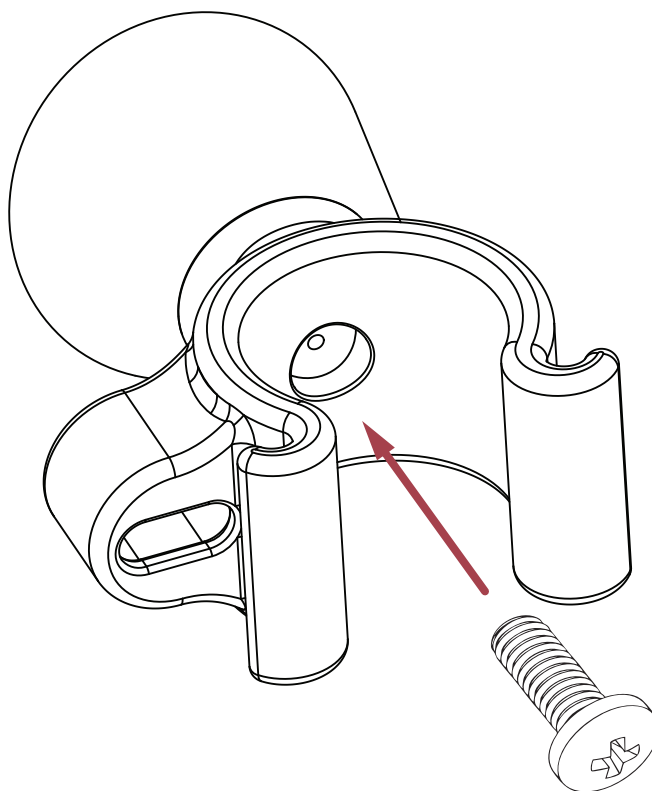


3D print the part diamond bottom and top using TPU filament and the following settings.



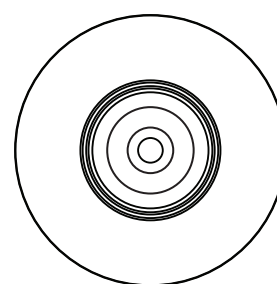
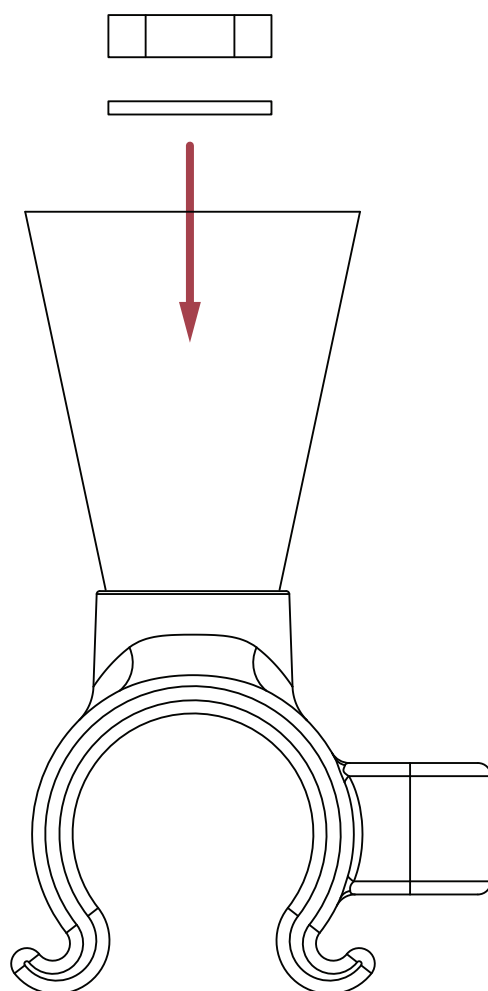
Insert the flat part of the Diamond bottom part, into the flat and round part of the Collapsible ring.

5

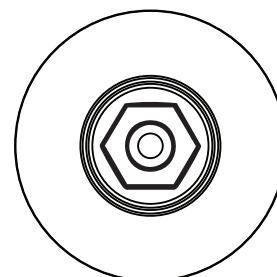


Insert a bolt from the inner ring of the Collapsible ring and screw it all the way in.

6



1

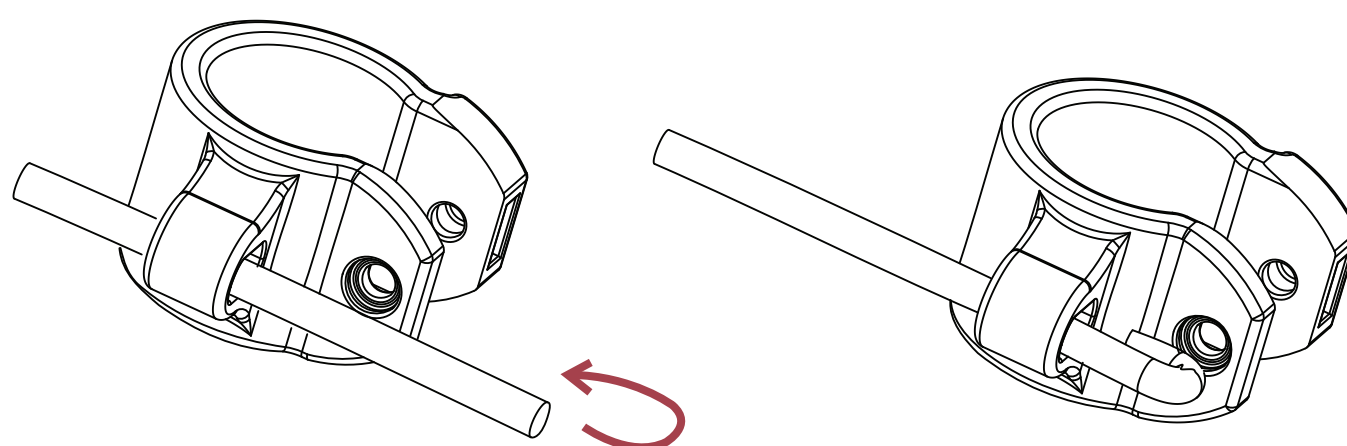


2

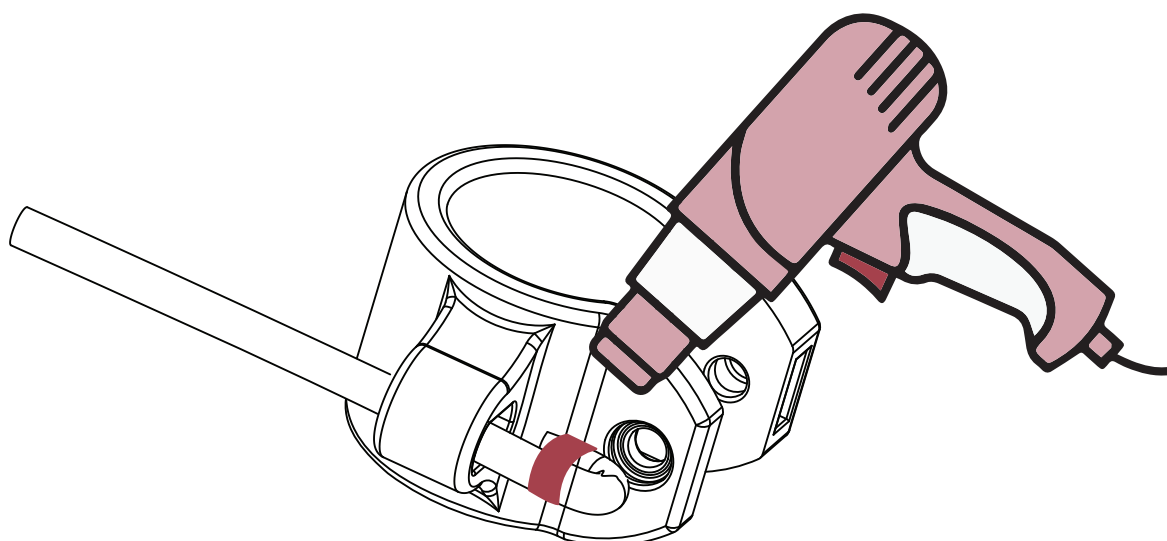
Insert a washer onto the bolt from inside the main diamond part, then add a nut and tighten it on top until fully secured.



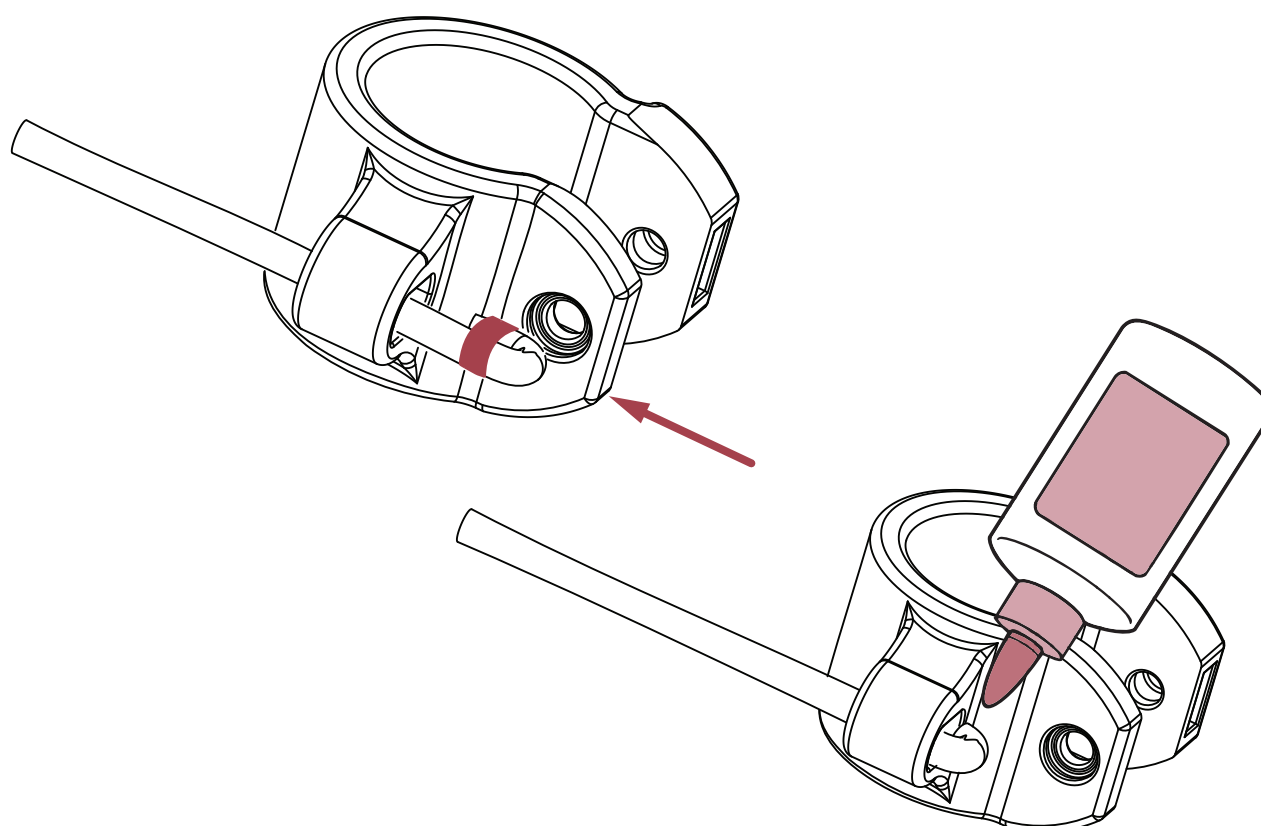
Apply glue to the edge of the Diamond main lip. Close it with the Diamond top as illustrated and ensure a firm and secure bond.



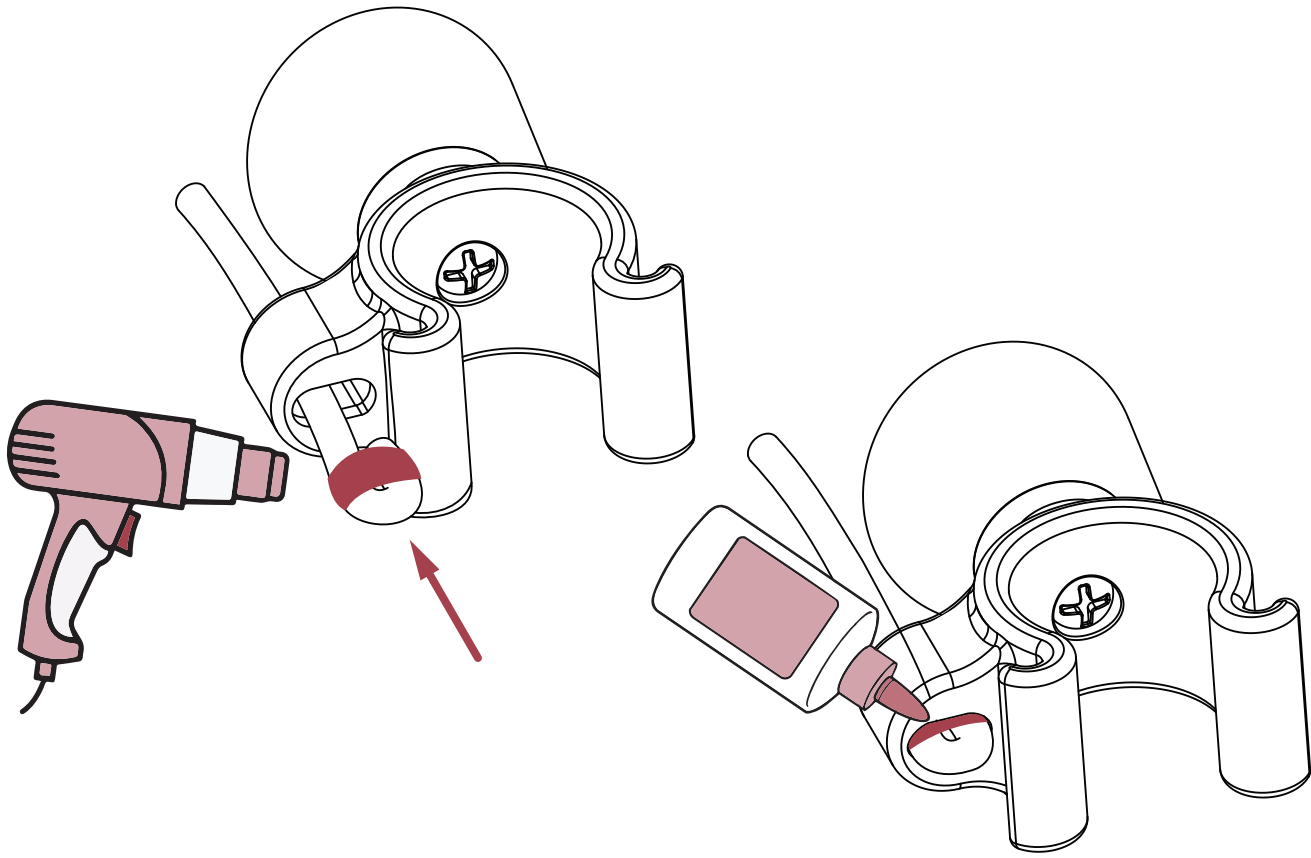
Thread the rope into the side hole of the Collapsible ring from the narrow side. At the wide side fold 7 mm of the rope back in.



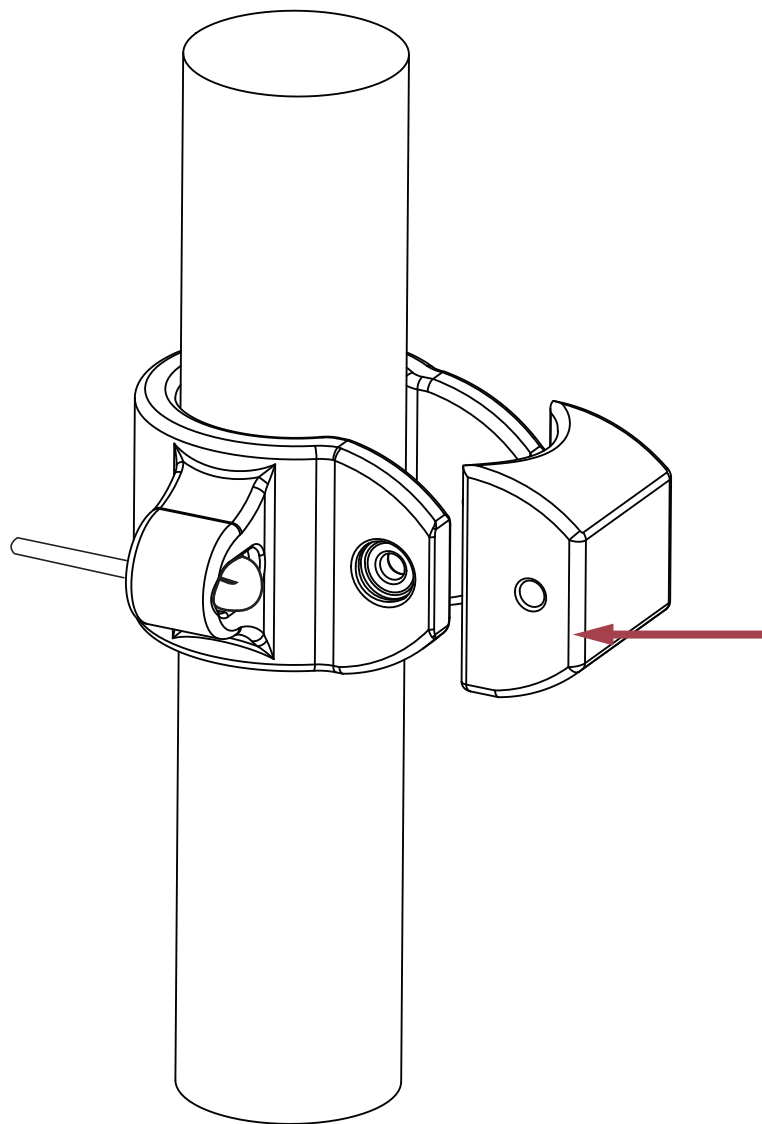
Place heat-shrink tubing over the folded rope and secure it using a heat blower.



Insert the folded, heat-shrunk section of the rope into the wide of the hole in the ring, then apply glue on top to secure it.

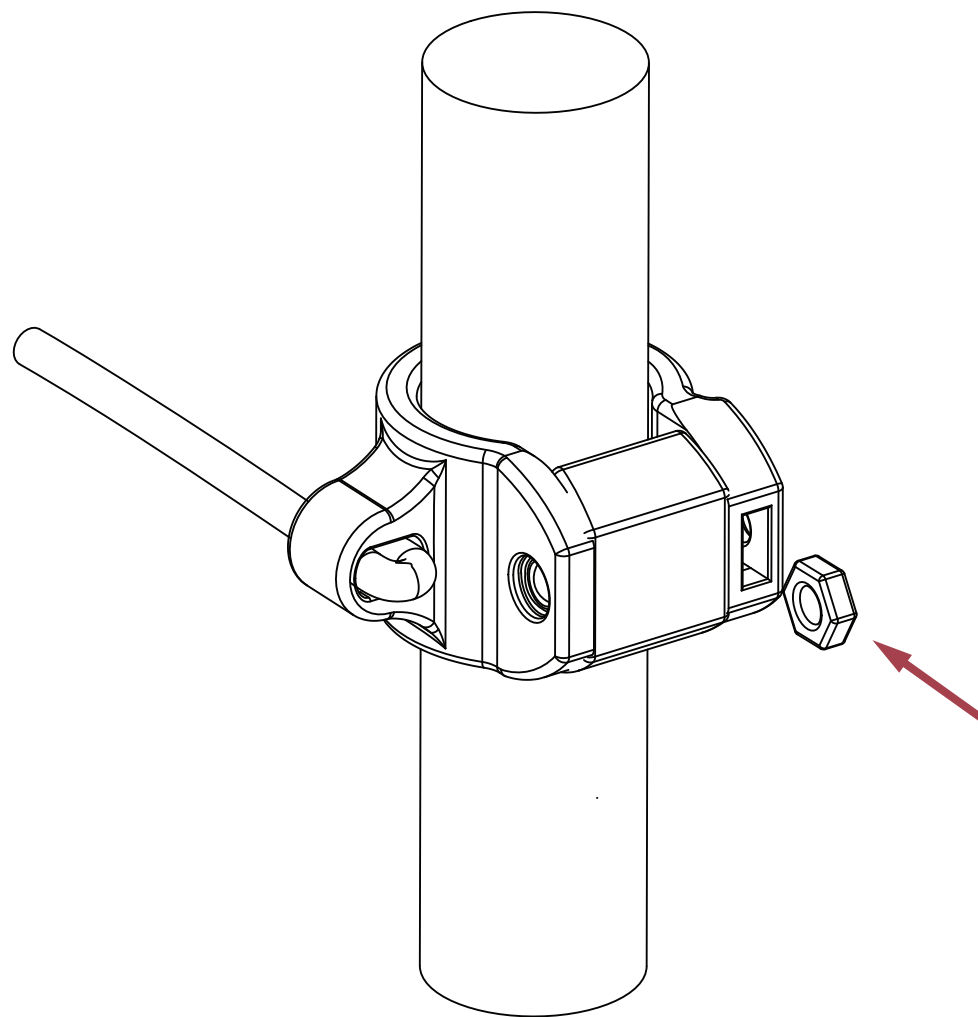


Repeat steps 6–8 for the Collapsible ring part as well.



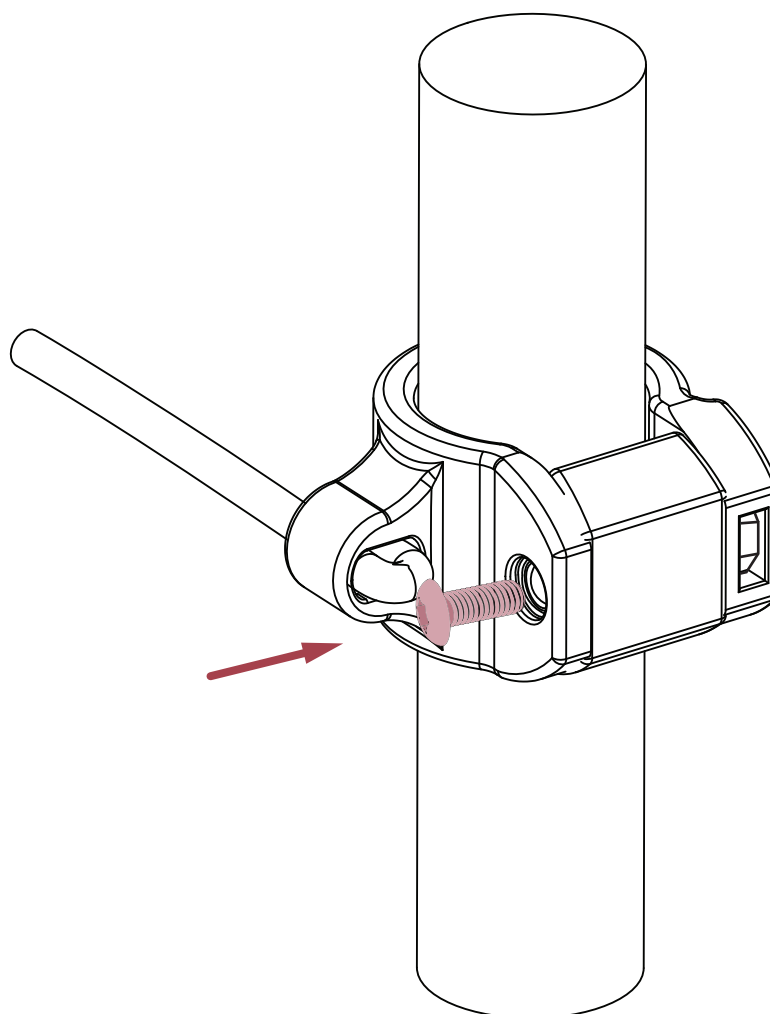
Place the Permanent ring onto the crutch and add the additional component, the Permanent ring lock.

13



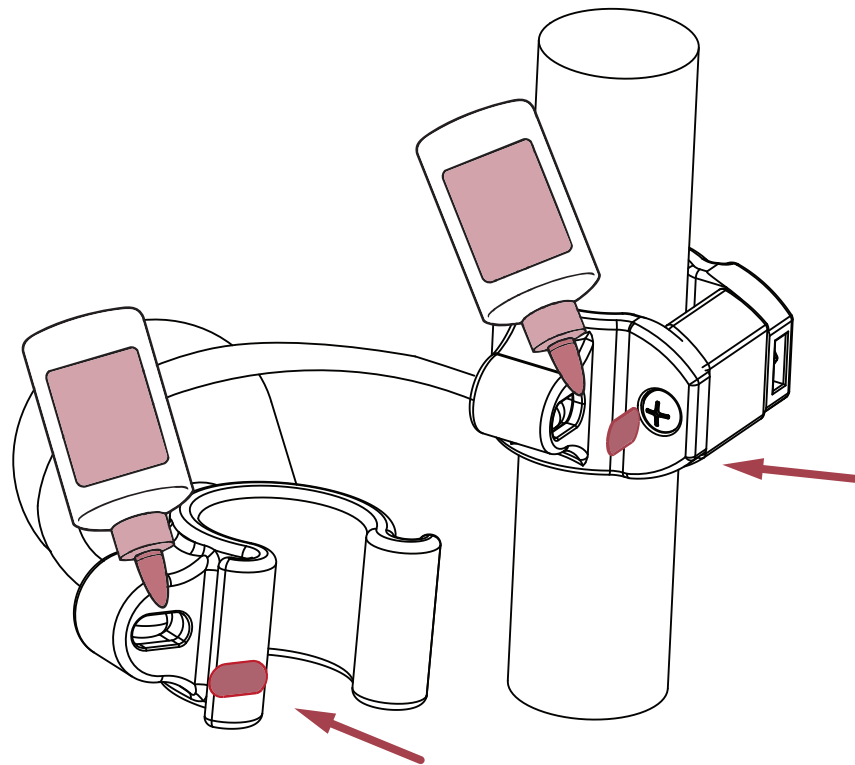
Insert the nut into the designated hole in the Permanent ring main.

14

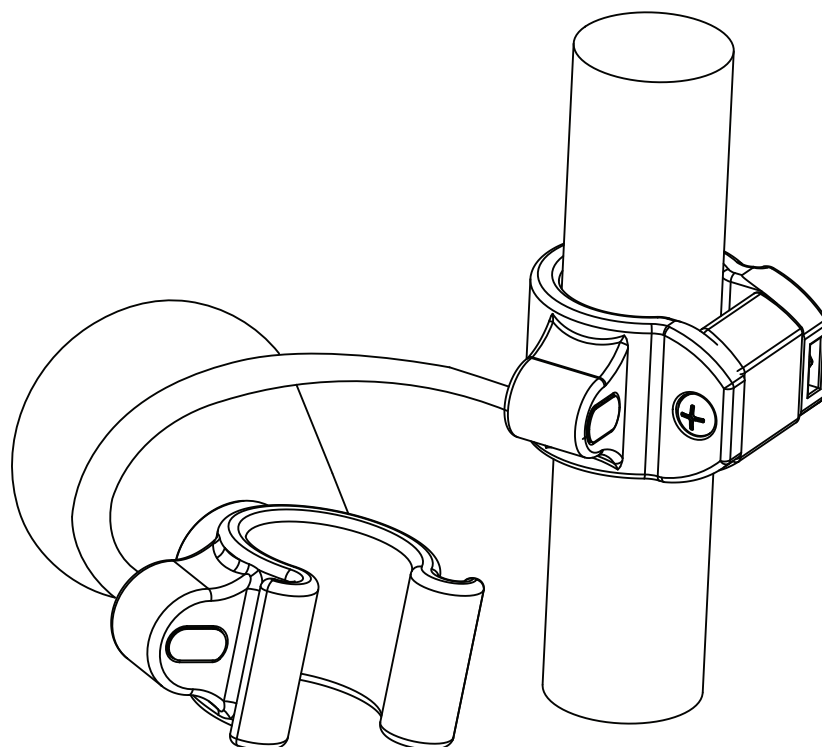


Insert the screw through the shared channel formed between all components and tighten fully.

OPTIONAL



Apply glue to the grooves formed above the ropes inserted into the components, then insert the coverage parts.



All done and ready to use!