

Fillamentum PP 2320

(Polypropylene)

Printing temperature: 225 – 245 °C

Heated bed temperature: 90 – 105 °C

Speed: 20 – 40 mm/s

Part cooling fan: 0 – 50 %

Heated bed surface: Polypropylene plate, mirror / glass

Adhesive: Magigoo PP

Raft / skirt / brim: Brim 10 mm / raft

Heated chamber / enclosure: recommended

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- Adhesion** - You can also print PP on the packing tape. In that case we recommend using with raft, because PP can easily adhere to well to packing tape.
- Storing** - Airtight bag with silica gel.
- Cooling** - For standard maximum part cooling fan speed is 15 % from 10th layer. If you are printing difficult parts / models with overhangs and supports, you can go up to 50 %. Be careful with the part cooling fan speed – too much flow can increase warping effect.
- Printing** - Printing bridges with PP could be challenging, for standard use we recommend using supports as it really helps and avoids print fails.
Stronger parts can be achieved by increasing the temperature up to 240-245 °C, where layers adhere more. Printing very small features is hard. We recommend avoiding them in the models, as they could deform / print not well.
Printing in vase mode is almost impossible without heated chamber. Material shrinks very much.