

3D printing guide

Fillamentum PP 2320

(Polypropylene)

Printing temperature: 225-245 °C

Hotbed temperature: 90-105 °C

Speed: 20-40 mm/s

Part cooling fan: 0-50 %

Hotbed surface: Polypropylene plate, mirror/glass

Adhesive: Magigoo PP

Raft/skirt/brim: Brim 10 mm / raft

Heated chamber/enclosure: recommended

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.