



Recommendations for printing with flexible material

Before start of printing from the flexible materials, it's required to check which version of the firmware is installed on the printer:

- 3DGence ONE: *OK* → *Info* → *SW*,
- 3DGence DOUBLE P255: *Menu* → *Advanced* → *Printer info* → *Firmware*,
- 3DGence INDUSTRY F340: *Menu* → *Info* → *Firmware*.

In case, when firmware version is older then:

- for 3DGence ONE: 3.1.4. (06.06.2017),
- for 3DGence DOUBLE P255: 1.1.4 (04.12.2018),
- for 3DGence INDUSTRY F340: 3.3.9 (27.06.2019).

It's required to install actual version of the firmware, which is available on the website:

www.3dgence.com/support in the tab FIRMWARE (the firmware tab is available after creating an account and registering the device).

3DGence recommends printing flexible materials using a separate hotend/separate module due to the properties of flexible materials. Using the same hotend interchangeably for printing flexible materials together with other materials may cause problems with loading the material and improper feeding during the printing process.

In case of using the same hotend for many materials before loading flexible material, user should:

1. Load the HIPS filament using the material loading assistant and follow the instructions on the printer display.
 - In case of printer 3DGence ONE: when selecting the material loading temperature, set the temperature to 240°C.
 - In case of printer 3DGence DOUBLE P255 and INDUSTRY F340, select on the display HIPS button, which applies 250°C.
2. Clean the hotend:
 - For 3DGence ONE: warm up the hotend using the Preheat to ABS option. After warming up the hotend press the "+" button, extrude approx. 10 cm of filament.
 - For 3DGence DOUBLE P255: by choosing from the printer's menu: *Materials* → *Clean nozzle*.
3. Unload the HIPS filament using the material unloading assistant and follow the instructions on the printer display.
4. Load the flexible filament using the material loading assistant and follow the instructions on the printer display.
 - in case of printer 3DGence ONE: when loading the material manually set the temperature to 210°C.
 - In case of 3DGence DOUBLE P255 and INDUSTRY F340, select the FLEX button.

Flexfill 98A (Filamentum)

Before printing, one layer of Dimafix should be applied to the heatbed. For larger prints - more than 50% of the heatbed surface, it's recommended to apply two layers of Dimafix. After printing, wait until the device cools down, and then remove the model from the heatbed. For removing the support it's recommended to use the pliers.



3DGence | Przyszowice Office | Graniczna 66, 44-178 Przyszowice, Poland
www.3dgence.com

Flexfill 98A (Filamentum)+ESM-10 [3DGence]

Before printing, four layers of Dimafix should be applied to the heatbed. After printing, wait until the device cools down, and then remove the model from the heatbed. For removing the support it's recommended to use 3DGence Support Dissolving System or pliers.

InnoFlex 60 [Innofil3D]

Before printing, at least two layers of Dimafix should be applied to the heatbed. For large models covering over 50% of the heatbed surface, it is recommended to use four layers of Dimafix. After printing, wait until the device cools down, and then remove the model from the heatbed. In case of problems with removing the model from the work platform, heat the heatbed to 60°C and gently pry the model with a spatula, then remove it from the heatbed. After removing the model, turn off the heatbed heating.