



Recommendations for printing with [3DXTech] + HIPS-X [Spectrum] materials Recommendations for printing with ASA [Filamentum] + HIPS-X [Spectrum] materials

The materials should be dried before printing to remove any moisture that the material has absorbed. After unpacking from the box, it is recommended to dry the materials at temperature 50 - 60°C for approx. 8 hours. You can use the 3DGence INDUSTRY F340 printer, INDUSTRY F420 working chamber or a dedicated dryer for this purpose. The materials should be printed in an environment with humidity below 40%. When printing in a high humidity environment, use a fabric dryer or store the material in the heated filament chamber. After drying store the materials in a heated chamber.

When printing with moist material, the following may occur:

- problem with layer lamination,
- characteristic foaming of the printed material,
- repetitive communicate of material feeding error.

ASA [Filamentum] + HIPS-X [Spectrum] materials

Before printing, two layers of Dimafix should be applied to the heatbed.

ASA [3DXTech] + HIPS-X [Spectrum] materials

Before printing, one layer of Dimafix should be applied to the heatbed.

After printing, wait until the device cools down, and then remove the model from the heatbed.

It is recommended to use pliers for removing supports and wear eye protection glasses.