



## Recommendations for printing with PP Cenatur [Formfutura]

The recommendations are different depending on the printer and type of support material.

### 3DGence INDUSTRY F340 printer

#### ➤ **PP with support material HIPS:**

- The temperature in the filament chamber should be set on 30°C.
- The matt structure of the bottom surface of the model results from the manner in which the models stick to the support structures.

#### ➤ **PP with support material BVOH:**

- The temperature in the filament chamber should be set on 30°C.
- Model material (PP) is characterized by high shrinkage, therefore deformations of models with right angles may occur.
- During printing, there may be some problems with sticking small (about 2 cm<sup>2</sup>) support structures to the model material. In this case, change the support angle or use a profile with HIPS as a support material.
- The matt structure of the bottom surface of the model results from the manner in which the models stick to the support structures.

#### ➤ **PP without support material:**

- Before printing, one layer of Magigoo PP should be applied to the heatbed.

### 3DGence DOUBLE P255 printer

#### ➤ **PP with support material HIPS:**

- Model material (PP) is characterized by high shrinkage, therefore deformations of models with right angles may occur.
- The matt structure of the bottom surface of the model results from the manner in which the models stick to the support structures.
- It is recommended to print PP material in a dedicated chamber.



Due to the high material shrinkage of PP and the printing technology of support structures, it is recommended that during the 3D modelling stage add adhesive circles with a diameter between 6-10mm and a height of 0.5-1mm. This will facilitate proper maintenance of the model on the support material during the printing process.

