



Recommendation for printing with PEEK CF10 LS1 KetaSpire [Solvay] + ESM-10 [3DGence] materials

Before printing, remove the dirt from the heatbed with a damp cloth and wipe dry with a paper towel, then clean the heatbed with isopropyl alcohol, on the spotless surface apply the first thin layer of Dimafix specimen. After dry, apply another layer repeat the operation until 3 thin layers of adhesive are obtained. Each time take care to evenly distribute the adhesive.

The material 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 material at a temperature 150°C for not less than 4 hours. You can use the dedicated dryer for this purpose. The material should be dried before each printing if the interval between printouts was more than 24h. The unused material should be stored in a foil package together with the desiccant sachet in a shaded, damp place. During work with material it is recommended to use protective gloves.

When printing on the moist material, the following may occur:

- problem with layer lamination,
- characteristic foaming of the printed material,
- repetitive communicate of material feeding error,
- increased flossing,
- visual deterioration of the seam.

It is recommended to use 3DGence Support Dissolving System and pliers for removing supports, and wear eye protection glasses. Printouts should be removed only after the heatbed and the printer's chamber will reached the temperature equal to or lower than 50°C.