PP (Polypropylene)

Use the following configuration:

1. Clean brass 0.4 mm nozzle (dddrop's standard);
2. Lighter spring for extruder (included with your PP filament reel);
3. Filamentreel of dddrop PP;
4. FFF profile PP (https://www.dddrop.com/dddrop-support/);
5. Magigoo PP (instruction of use is inside the Magigoo package); (https://www.dddrop.com/products/parts/)
6. Set the PP filament as shown in picture "Set filament in Filament Management Module".

Important notes:

1. The brim, which is enabled in the Simplify3D software, is necessary for a stable print process of PP. Don't disable the brim for any reason. This will cause bigger warping problems.

2. Keep the cover of the dddrop 3D printer always closed while printing a product. Don't open the cover for any reason. This will cause bigger warping and delamination problems.

3. Tested with products with dimensions of 50 x 50 x 50 mm.

4. The semi-crystalline structure of the material causes the 3D printed parts to heavily warp upon cooling, making it challenging to 3D print. The amount of warping depends on the type of product you print. Massive products will warp more than thin products.

5. Keep your filament dry. If you experience:
   - A lot of stringing or oozing;
   - Poor layer adhesion;
   - Uneven extrusion lines,

   It could be that your filament has to be dried. Use the PrintDry filamentdryer or an air-circulated oven. 70-80 degrees for 6-8 hours.

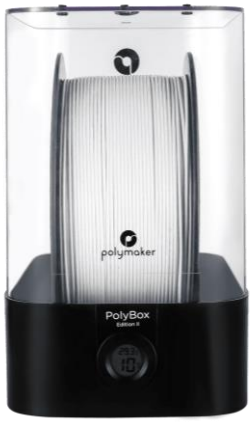
Tips:

1. After drying the filament, but not using it immediately, use a filament (vacuum) storage container to keep your filament dry for a longer time.

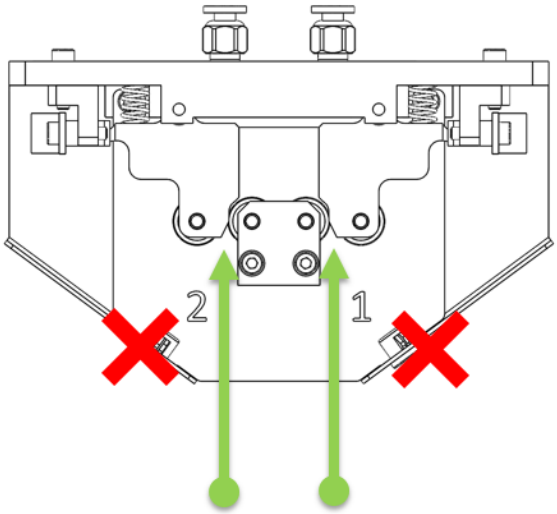
2. When printing large parts, use the Polybox filament container to put your filament in. While printing your filament is conditioned and free of moisture.

PrintDry

Filament storage container



Polybox



Set filament in Filament Management Module (FMM)

For any questions, don't hesitate to contact our Customer Service.
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