

TPU (Thermoplastic PolyUrethane)

Use the following configuration:

1. Clean brass 0.4 mm nozzle (ddd drop's standard);
2. Lighter spring for extruder (included with your TPU filament reel);
3. Filamentreel of ddd drop TPU;
4. FFF profile TPU (<https://www.ddd drop.com/ddd drop-support/>);
5. Dimafix (use spray or pen, it depends on which machine you have. (<https://www.ddd drop.com/products/parts/>).
6. Set the TPU filament as shown in picture 'Set filament in Filament Management Module'".



Important notes:

1. Always use Dimafix. When using Dimafix, never use the Ammonia heatedbed cleaner. The combination of Dimafix and Ammonia will damage your glassplate.
2. The brim, which is enabled in the Simplify3D software, is necessary for a stable print process of TPU. Don't disable the brim for any reason. This can cause bigger warping problems.
3. Keep the cover of the ddd drop 3D printer always closed while printing a product. Don't open the cover for any reason. This will cause bigger warping and delamination problems.
4. Tested with products with dimensions of 100 x 100 x 100 mm.
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 degrees for 6-8 hours.

Tips:

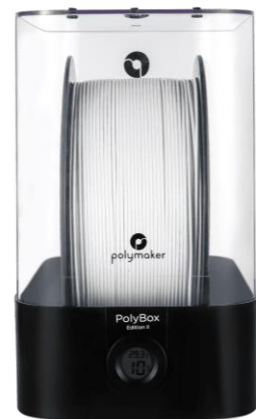
1. After drying the filament, but not using it immediately, use a filament (vacuum) storage container to keep your filament dry for a longer time.
2. When printing large parts, use the Polybox filament container to put your filament in. While printing your filament is conditioned and free of moisture.



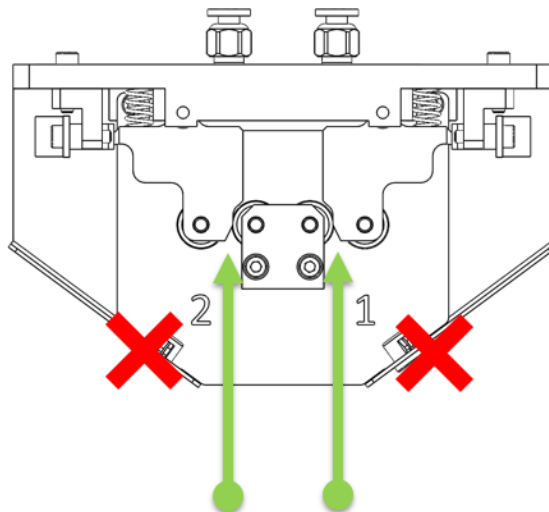
PrintDry



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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